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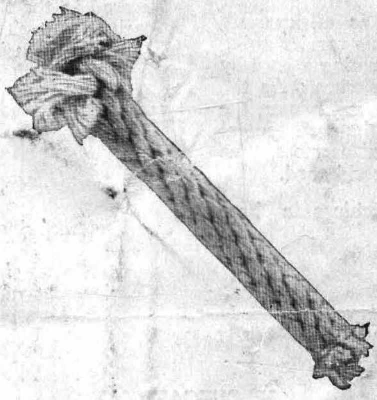
21H

CIRCULAR NO. 21

SASH CORD
OR
SOLID CORD MACHINES



Specimen of Cord made on the machines described in this circular.

NEBUTTCO

NEW ENGLAND BUTT CO.

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SOLID CORD MACHINES

THESE machines are used in the manufacture of window sash cords, clothes lines, signal pull ropes, trolley cord, window shade cords, awning lines, curtain cords, and for a great many other purposes where a solid, non-kinkable rope is desired.

The machines are designed and intended for use where a solid braided rope is required without a core. They can, however, be used with a core, the 12-Carrier being provided with spool holders beneath the machine for this purpose.

These machines differ from the familiar type of Braiders inasmuch as all carriers travel in the same direction, one carrier going under the two preceding it, forming a cord by producing a series of lock stitches. As the cord forms, it is drawn through a former, the function of which is to keep the cord central against the pull of the several carriers, thus forming an even, round and solid cord.

We manufacture these machines in three sizes, 9, 12 and 18-Carrier.

9-Carrier, No. 2 Cord Machine

This machine is designed to make cords from the smallest up to No. 6 (3/16″ dia.). The tension on the yarn is obtained by means of weights, actuated by gravity alone. The output of this machine is from 40 ft. to 65 ft. per hour, depending on the number of picks per inch.

12-Carrier, No. 3 Cord Machine

This machine is designed to make cords from No. 6 (3/16″) to No. 12 (⅜″). The tension on the yarn is obtained by standard size weights, actuated by gravity on first part of lift, and the final pull on each stitch is delivered to the thread by means of springs in each weight. These springs can be furnished in several tensions. One attendant can run from thirty to forty machines. The output of this machine is from 60 ft. to 100 ft. per hour.

18-Carrier, No. 4 Cord Machine

This machine is designed to make cords up to and including, No. 20 (⅝″ dia.). It is otherwise of similar construction, to the 12-Carrier, but of larger size. The output of this machine is from 80 ft. to 115 ft. per hour.

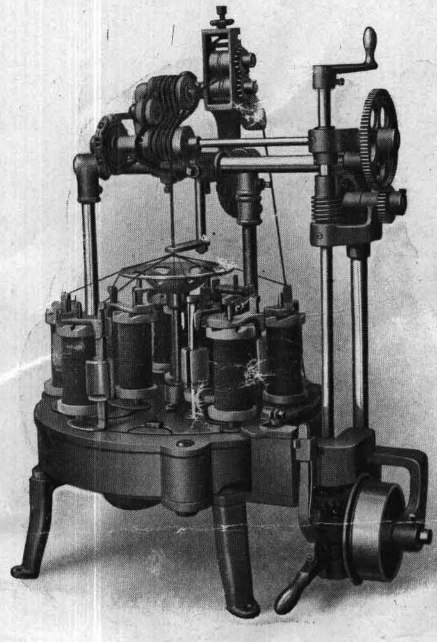
SPECIFICATIONS

	9-Strand Large	12-Strand	18-Strand
Picks per Min.	124	102	72
Size Pulley	5 x 1⅝	8 x 1¾	12 x 3¼
Style Pulley	Clutch	T & L	Friction
Pulley Speed	250	230	215
Carrier Speed	30 RPM	25½ RPM	20½ RPM
1 Horse Power	25 Machines	5 Machines	2 Machines
Net Weight	165	380	830
Gross Weight	240	575	1170
Cubic Feet, boxed	7	25	32
Floor Space	23″ x 22″	33″ x 30″	36″ x 36″
Bobbin Capacity	4½ oz.	12 oz.	12 oz.

Sash Cord is Put Up in 100 Ft. Hanks

Weights of the various sizes for 100 ft.

No. 6	1¼ lbs.	No. 12	4¼ lbs.
No. 7	2 lbs.	No. 14	6¼ lbs.
No. 8	2¼ lbs.	No. 16	8½ lbs.
No. 9	2¾ lbs.	No. 18	10½ lbs.
No. 10	3¼ lbs.	No. 20	13 lbs.



9-Carrier Cord Machine, No. 2

Code Word, "Bet"

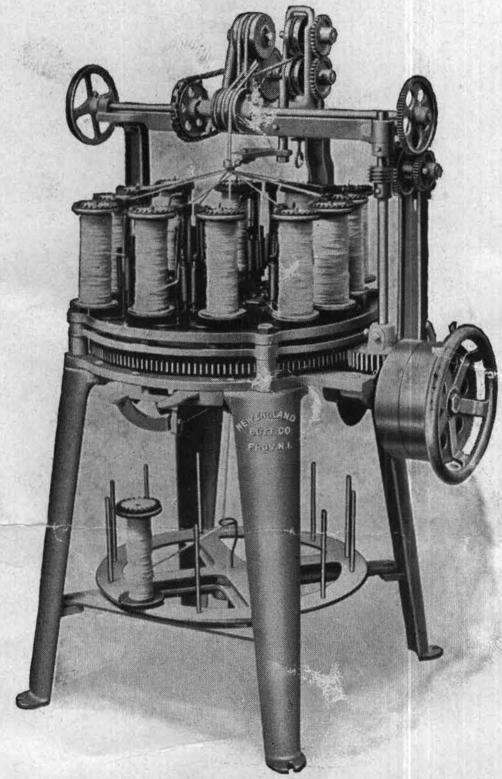
This machine is built with short legs and is intended to be used on a bench.

It takes bobbins 2½″ diameter, 3¾″ traverse, or it can be fitted to use cops. Bobbins or cop holders are not included in the price of the machine.

One set of tension weights is furnished with each machine. These can be of any size from 2½ oz. to 16 oz. Each machine is furnished with 6 change gears for varying number of picks in the cord.

For making very hard cord we can furnish spring carriers at an extra cost. These special carriers take bobbins 2-5/16″ diameter, 4½″ traverse.

For dimensions, see table on previous page.



12-Carrier Cord Machine, No. 3

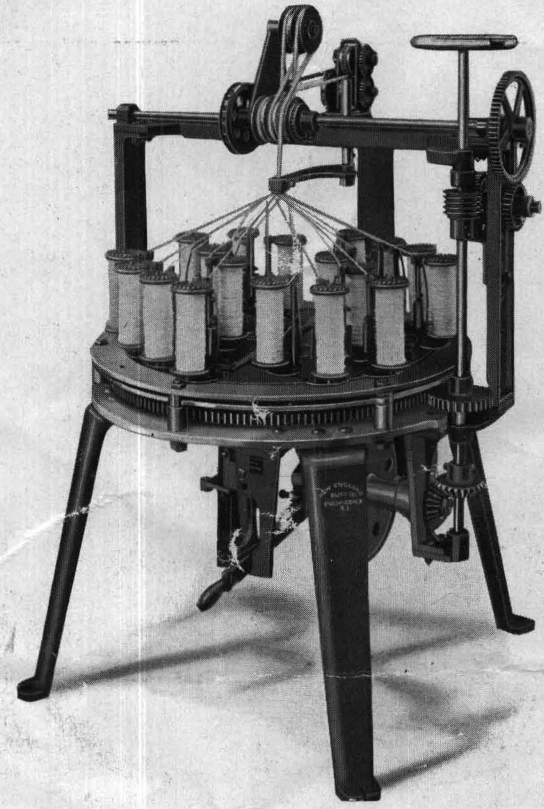
Code Word, "Betimes"

This machine is built with high legs.

It takes bobbins 3¼″ diameter, 6″ traverse. Bobbins are not included in the price of the machine and must be ordered extra.

Each machine is furnished with 5 sizes of former dies and 6 change gears for varying number of picks in the cord.

For dimensions, see table on previous page.



18-Carrier Cord Machine, No. 4

Code Word, "Enotose"

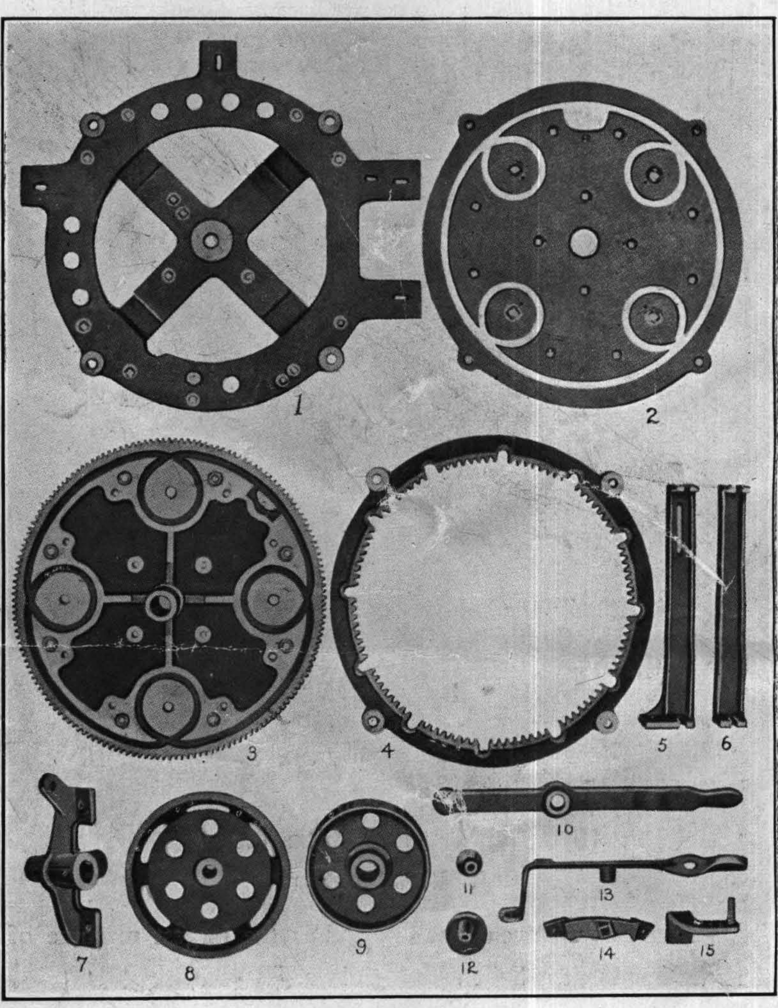
This machine has eighteen carriers, and is the largest machine of this kind which we build. It is built with high legs.

It takes the same size bobbins as the 12-Carrier Machine, 3¼″ diameter x 6″ traverse.

Bobbins are not included in the price of the machine, and must be ordered extra.

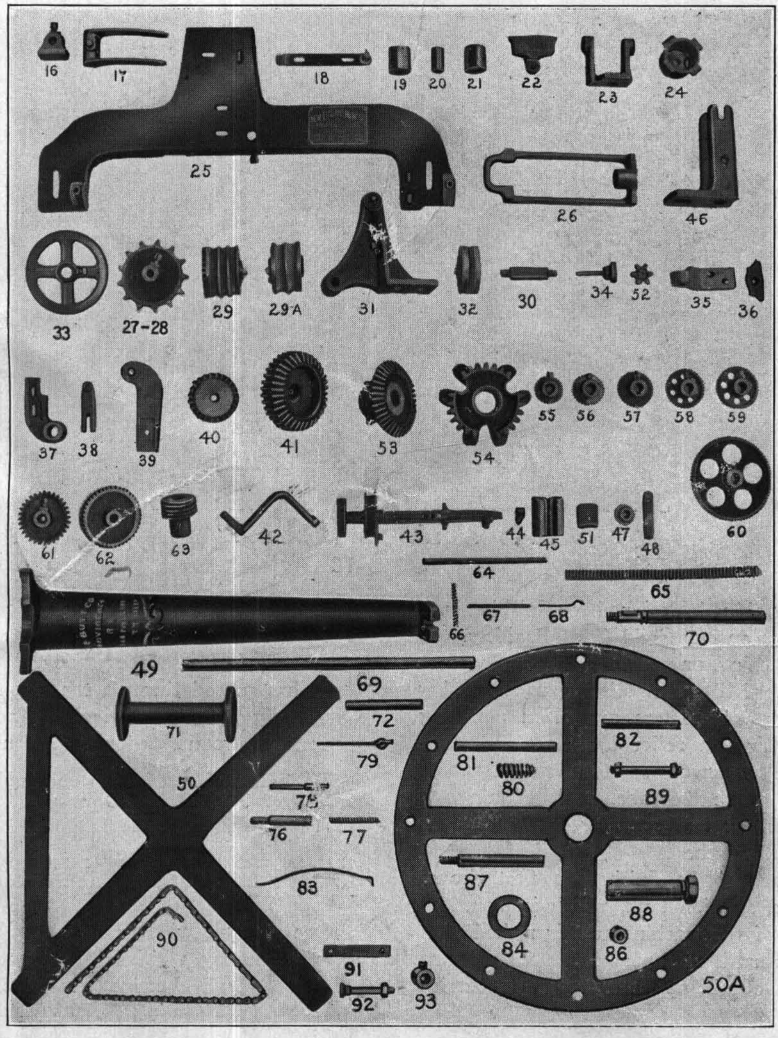
Each machine is furnished with 5 former dies and 6 change gears for varying the number of picks in the cord.

For dimensions, see table on previous page.



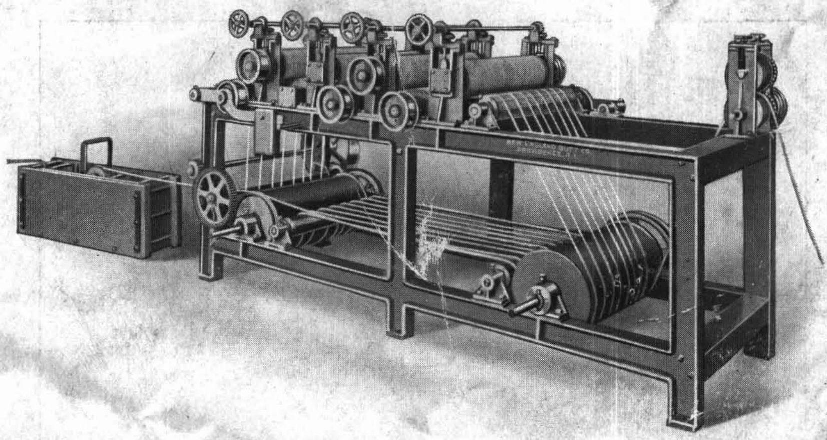
Names of Parts of 12-Carrier Cord Machine

1 Bottom Plate
2 Top Plate
3 Centre Plate
4 Internal Gear
5 R. H. Upright
6 L. H. Upright and Back Brace
7 Shaft Bearing
8 Pulley and Hand Wheel
9 Loose Pulley
10 Shipper Lever
11 Shipper Lever Bushing
12 Oil Drip Cup
13 Trip Lever
14 Trip Lever Guide
15 Trip Lever Fulcrum
16 Shipper Rod Dog
17 Shipper Fork
18 Stop Motion and Stud
19 Horn Gear Bushing
20 Small Bushing
21 Outer Bushing
22 Top Plate Button
23 Worm Gear Bearing
24 Stop Motion Centre
25 Cross Bar
26 Take-off Tension Frame
27 Cross Shaft Sprocket 14 T
28 Feed Roll Sprocket 13 T
29 Lower Feed Roll
29A Upper Feed Roll
30 Quoit Stud (square) and Nuts
31 Feed Roll Stand
32 Take-off Roll
33 Scored Pulley
34 Tension Screw
35 Shipper Rod Bearing
36 Centre Plate Button
37 Bolster
38 Former
39 Former Arm
40 Bobbin Ratchet
41 Crown Drive Gear
42 Lower Former
43 Carrier without weight
44 Carrier Latch
45 Carrier Weight complete
46 Take-off Roll Frame
47 Stop Motion Roll
48 Latch
49 Leg
50 Warp Rim Bracket



Names of Parts of 12-Carrier Cord Machine

50A	Warp Rim
51	Stop Motion Centre Guide
52	Tension Screw Check Nut
53	Drive Shaft Gear
54	Horn Gear
55	28 Tooth Change Gear
56	30 Tooth Change Gear
57	34 Tooth Change Gear
58	38 Tooth Change Gear
59	42 Tooth Change Gear
60	82 Tooth Change Gear
61	Take-off Roll Gear
62	Worm Gear
63	Worm
64	Carrier Spindle
65	Shipper Rod Spring
66	Carrier Latch Spindle Spring
67	Carrier Latch Spindle
68	Carrier Spindle Spring
69	Upright Shaft
70	Main Drive Shaft
71	Bobbin
72	Worm Gear Shaft
73	Shipper Rod
74	Cross Shaft
75	Stop Motion Screw
76	Feed Roll Stud
77	Carrier Weight Spring
78	Carrier Weight Plunger
79	Warp Guide
80	Take-off Roll Spring
81	Lower Take-off Roll Shaft
82	Upper Take-off Roll Shaft
83	Thread Guide
84	Ball Thrust Bearing
86	Cross Shaft Collar
87	Drop Former Stud
88	Centre Stud and Nut
89	Rim Stud and Nuts
90	Sprocket Chain
91	Stop Motion Plate
92	Plate Bolt and Nut
93	Upright Shaft Collar
94	Warp Bobbin Spindle
95	Centre Tube and Nut
96	Weight Retainer
97	Weight Retainer Screw
98	Split Former Bushing (give size of hole)
99	Latch Spindle Cotter Pin
100	Weight Plunger Cotter Pin
101	Centre Warp Stud
102	Latch Screw
103	Take-off Spring Plug



NEW ENGLAND BUTT CO.
PROVIDENCE, R.I.

SASH CORD FINISHING MACHINE

Code Word, "Enoeabamur"

D-10

This machine is designed for finishing sash cord made on our Solid Cord Braiders.

The finishing, or polishing, is done by passing the cord between polishing rolls running at high speed. There are seven polishing rolls running in roller bearings, and these rolls are arranged so that they can be adjusted, while the machine is running, to bring more or less pressure on the cord as it passes through.

The cord to be finished is first drawn through a solution tank, which is placed at the back of the machine and furnished with it. The cord is then passed into the machine around the take-up sheave, and is carried twenty or more times around the machine. On each turn, it passes over two steam drums to facilitate the drying. When the cord has passed through the machine, it is practically dry and is delivered either in wire baskets, or wound on large wooden reels.

The solution tank is of wood, and contains six idler sheaves over which the cord is passed. These sheaves are carried in iron frames, which are easily removed to facilitate the cleaning of the tank.

One machine will finish about 54,000 feet of cord per day, which is the output of sixty 12-Strand Cord Machines, on No. 8 cord.

SPECIFICATIONS

Power required	5 H. P.
Speed of Countershaft	275 RPM
Size of T & L Pulleys on Countershaft	16″ x 6″
Speed of Steam Drums	26 RPM
Speed of Polishing Rolls	1,200 RPM
Size of Solution Tank	36″ long, 18″ wide
Depth of Solution Tank	25½″
Floor Space of Machine	9′ 6″ x 4′ 2″
Floor Space of Machine with Solution Tank	13′ 6″ x 4′ 2″
Net Weight	3,300 lbs.
Gross Weight	5,000 lbs.
Cubic feet, boxed	100